

Work Order ID 119471

119471

Page 1

Monday, June 09, 2014 11:33:07 AM

Item ID: D3405-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gh Lug

Start Date: 5/21/14

Start Qty: 80.00

80

Cust Item ID:

Required Date: 5/21/14

Req'd Qty: 80:00

80

Customer:

Reference:

Approvals:

Process Plan:

Date: 14.6.9

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO: 24545

CUT AS PER DRWG: D3405 REV B

CL 14/06/12 80

115

Receive & Inspect for Damage & Mat'l Certs

0.00

115

Packaging

Memo

0.00

Packaging

P-14/7/12 (80)

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

(80)

DAS
9
9-89

14/08/13

Work Order ID 119471

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Page 2

Monday, June 09, 2014 11:33:07 AM

Item ID: D3405-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Gh Lug
 Start Date: 5/21/14 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00 0.00				79X			14/10/14 PTC DAS 36 9-89
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140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				79	14-10-16		DAS 9 9-89
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150 *150* Large Fab Large Fab	Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-041 128077	0.00 0.00				38		15-06-22 JSE	
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Work Order ID 119471

Monday, June 09, 2014 11:33:07 AM

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Page 3

Item ID: D3405-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Gh Lug
 Start Date: 5/21/14 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160						(33)	15-06-23		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
170	QC5- Inspect part completeness to step on W/O	0.00							
170						(33)	15-06-23		DAS 9 9-89
QC	Memo	0.00							
Quality Control									
180	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00							
180	m 131545					38	15-6-24		DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:25 OVEN TEMPERATURE: 100° FINISH TIME: 9:55								

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Item ID: D3405-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Gh Lug
 Start Date: 5/21/14 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 5/21/14 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				(38)			DAS 38 9-89 JUN 24 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>81529</u> Memo	0.00 0.00				38x			DAS 26 9-89 JUN 24 2015
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				ML5			JUN 29 2015 MF 15-6-25

Picklist Print

Monday, June 09, 2014 11:33:37 AM

Page 1

Work Order ID: 119471

119471

Parent Item: D3405-041

D3405-041

Parent Item Name: Gh Lug

Start Date: 5/21/14

Required Date: 5/21/14

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP A05.09.01New issueKJ/JLM
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	110.0000	1	80			

D3404-1

GHW/ Lug

**

PL 15-2-20

121116 x 40
121116 x 38

Location

Loc Qty

Loc Code

WA001

110

110801

30

113798

40

119610

40

MSC 15-06-22

M304S11GA

Purchased

No

150

sf

138.3000

0.154

13

M304S11GA

304/316 0.125 Sheet

**

CL 14/06/19

Location

Loc Qty

Loc Code

MAT020

138.3

122521

30

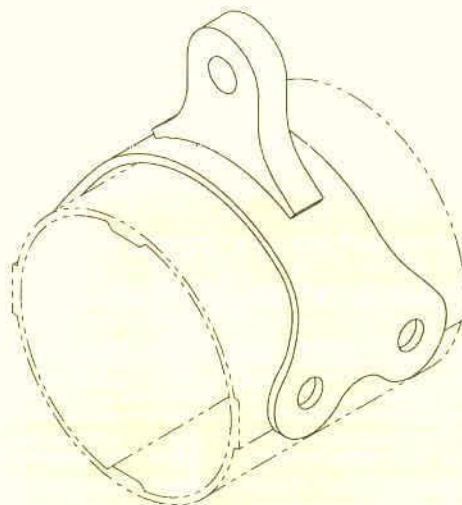
M128254

108.3

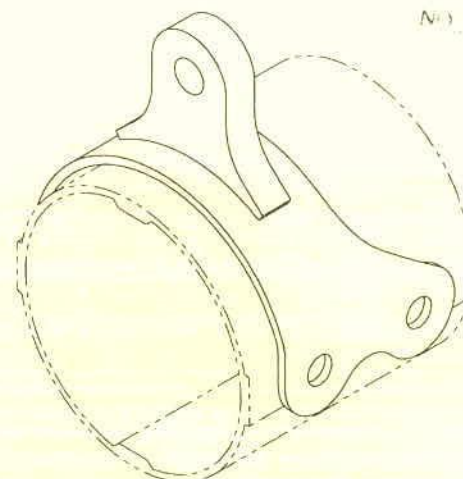
M129545

M129529

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

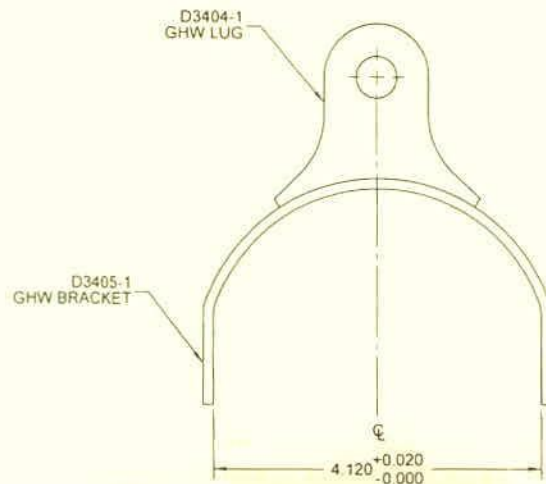
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

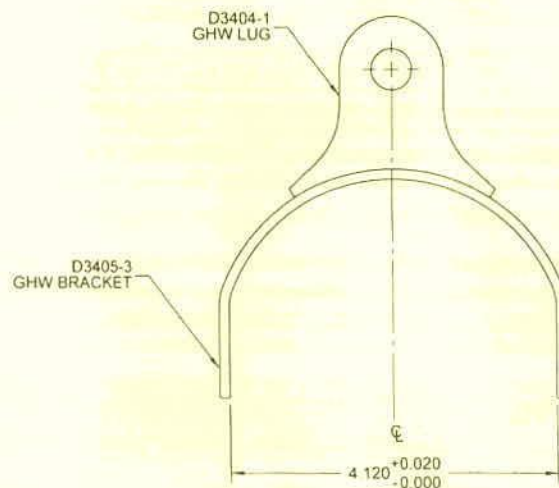
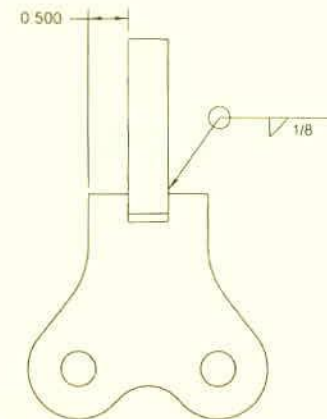
PROPERTY
RETURNED
TO THE
LIBRARY
OF THE
ARMY
WITH NO NOTICE
NO. 119471 M.L.S.
14-05-22

RELEASED
08/12/18 M.F.

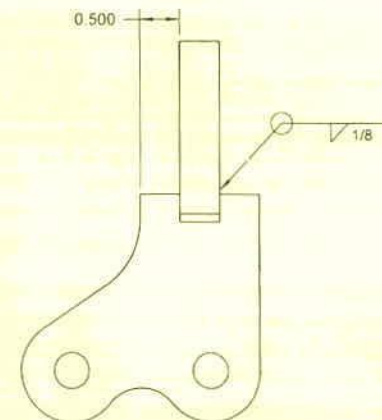
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3405-041 LUG ASSEMBLY

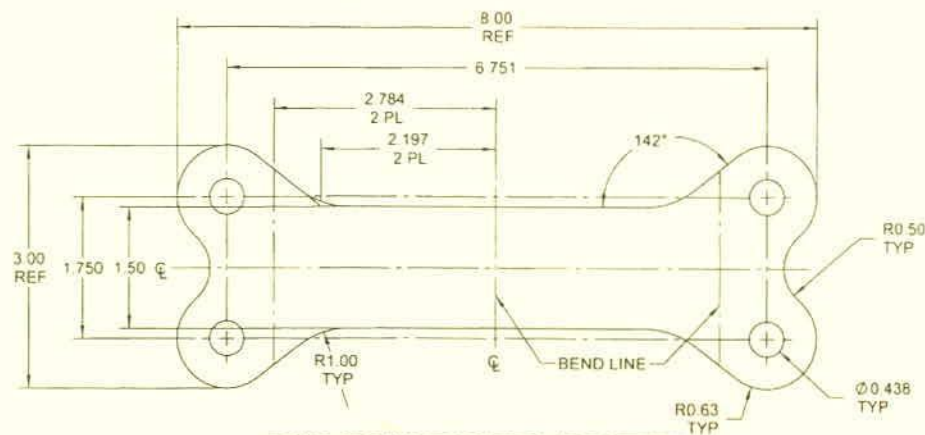


D3405-043 LUG ASSEMBLY

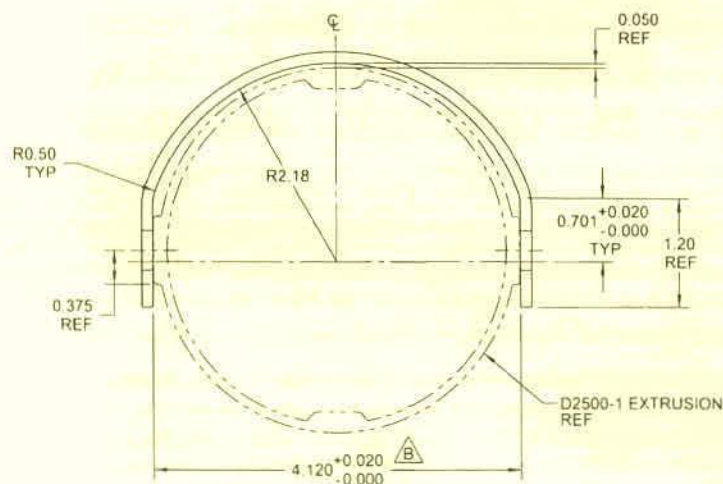


RELEASED
66/12/18

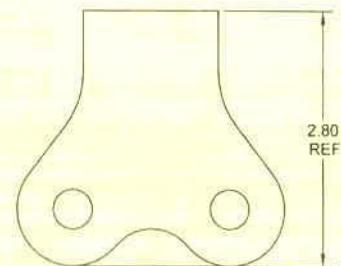
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. B
MFG. APPR		D3405	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR		GHW LUG ASSEMBLY	NTS
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



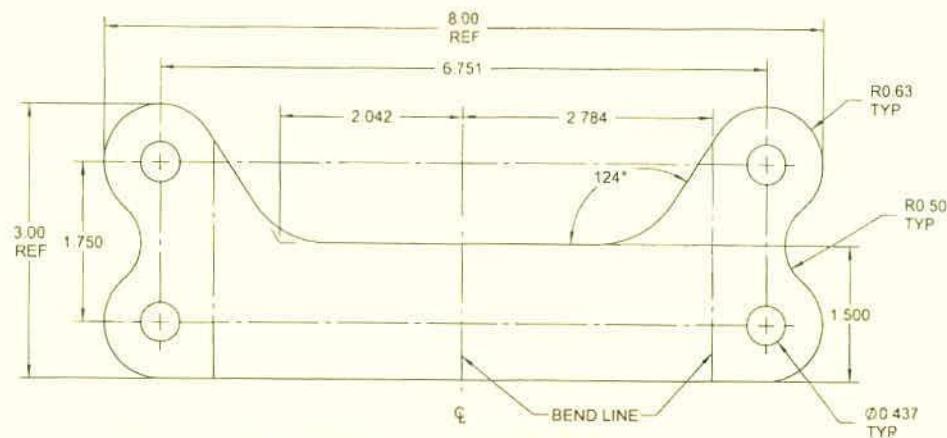
SIDE VIEW FOR REF ONLY

NOTES:

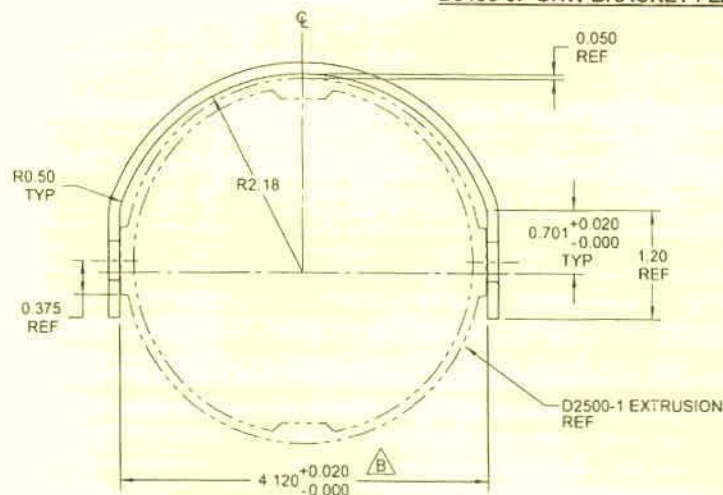
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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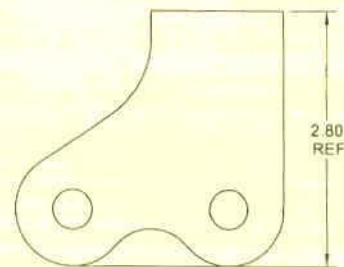
RELEASED
DYP 08/12/19



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG APPR		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR		GHW LUG ASSEMBLY	NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6181
Date: 2014-07-07
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 24545	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-07-07
Tracking No.:	

Item No.	Unit	Description	Quantity
d2232-3	Chaque	d2232-3 basket hinge	20
d2534	Chaque	d2534 lock plate	40
d3198-1	Chaque	d3198-1 fitting	24
d3405-041	Chaque	d3405-041 gh lugs	80
d3405-043	Chaque	d3405-043 gh lugs	40
d3561-1	Chaque	d3561-1 seal insert tool	20
d3912-5	Chaque	d3912-5 eyebolt plate	24
d3912-5	Chaque	d3912-5 eyebolt plate	24
d3913-15	Chaque	d3913-15 wide handle plate	30
d3953-19	Chaque	d3953-19 gas spring bracket	20
d3953-19	Chaque	d3953-19 gas spring bracket	20
d3953-21	Chaque	d3953-21 gas spring bracket	50
d3955-7	Chaque	d3955-7 plate	16
d4021-1	Chaque	d4021-1 handle plate	36
d4149-1	Chaque	d4149-1 crosstube lug plate aft	40
d4150-3	Chaque	d4150-3 arm plate	50
d4148-1	Chaque	d4148-1 crosstube lug plate fwd	40
d4151-1	Chaque	d4151-1 lower hardpoint plate	30
d4151-3	Chaque	d4151-3 upper hardpoint plate	40
d4151-3	Chaque	d4151-3 upper hardpoint plate	48
d4419-1	Chaque	d4419-1 fwd support plate	6
d4419-3	Chaque	d4419-3 aft support plate	6

Comment: Net / 30 from date of invoice 2% svc. chg. on invoices over 30 days